

Date: Thursday, 14/08/2008 11:50:50 AM
 User: Linda Lacelle

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : STEP WELDMENT
 Job Number : 41245
 Estimate Number : 12576
 P.O. Number :
 This Issue : 14/08/2008 S.O. No. :
 Prsht Rev. : NC Part Number : D3562041
 First Issue : / / Type : LARGE FAB ASSY Drawing Number : D3562 REV E
 Previous Run : 41038 Project Number : N/A
 Material :
 Due Date : 21/08/2008 Qty: 2 Um: Each
 Written By :
 Checked & Approved By :
 Comment : Est Rev:A New Issue 06-11-09 JLM
 Est rev B ECN 987 07.10.09 EC verified by: DD
 Est Rev:C ECN1048 07-12-18 DD verified by:ec
 Est Rev:D 08-07-28 add chemical conversion coat DD
 verified by:EC

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 D2622120C Step Extrusion



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Qty Part # Description Batch:

1 D2622-120C Extrusion 39316

Check Material for any Dents or Defects

SAD 08/08/14 (2)

2.0 LARGE FAB 1 LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Cut D2622 extrusion as per Dwg D3562

2-Deburr and bevel ends for welding

SAD 08/08/14 (2)

3.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08.08.14 2

4.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

FL 08/08/15 (2)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Seq. #:

Machine Or Operation:

Description :

5.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

Handwritten signature and date: 08-08-28 2

6.0

D3560041

Arm Weldment



Comment: Qty.: 1.0000 Each(s)/Unit Total: 2.0000 Each(s)

ARM WELDMENT

Batch: *335295 = 1 340299 = 1*

Handwritten signature and date: 08-08-18 2

7.0

D3560043

Arm Weldment



Comment: Qty.: 1.0000 Each(s)/Unit Total: 2.0000 Each(s)

ARM WELDMENT

Batch: *335297*

Handwritten signature and date: 08-08-18 2

8.0

MS20600AD4W5

Blind Rivet



Comment: Qty.: 32.0000 Each(s)/Unit Total: 64.0000 Each(s)

Blind Rivet

batch: *106431*

Handwritten signature and date: 08-08-12 2

9.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1- Transfer drill Rivet holes as per dwg D3562. *SP*

2-Touch-up rivet holes with alodine as per dwg d3562

3-Rivet legs using Magnabond as per dwg D3562.

*****Ensure to wipe off any excess magnabond *****

A/R Magnabond 6398

Batch: *M16695*

Handwritten signature and date: 08/08/28 (2)

10.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Handwritten signature and date: 08/08/28 (2)

W/O:

WORK ORDER CHANGES

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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:

WORK ORDER NON-CONFORMANCE (NCR)

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STEP WELDMENT

Job Number: 41245

Part Number: D3562041

Job Number:



Seq. #:

Machine Or Operation:

Description :

11.0

D2734

Step End Plate



Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part Number

Description Batch

2 D2734

End Cap 339179

Handwritten signature 08-08-28

12.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Weld end caps as per Dwg D3562& QSI 004. Inspect for foreign objects as per QSI 024.

A/R Aluminum Rod M108031

2-Grind end cap welds flush as per Dwg D3562

Handwritten signature 08-08-28
Handwritten signature 08-08-28

13.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

Handwritten signature 08-08-29

14.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Handwritten signature 08-08-29

15.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

Handwritten signature

08/08/28

(X2)

16.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

START TIME:

11:30am

OVEN TEMPERATURE:

326°F

FINISH TIME:

12:00pm

Handwritten signature 08-08-29

(X2)

W/O:		WORK ORDER CHANGES					
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Machine Or Operation:

Description :

17.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Wing Walk as per Dwg D3562 and QSI 005 4.4

Batch: M108496

Handwritten initials

08-08-29

(XP)

18.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

Handwritten: 08/09/02 (X2)

19.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Assembly Kit

Handwritten: 40853

Handwritten: 1

Handwritten: 8/9/2

(2x)

20.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Handwritten: 08/09/02

Job Completion



Handwritten: MF 08-09-02

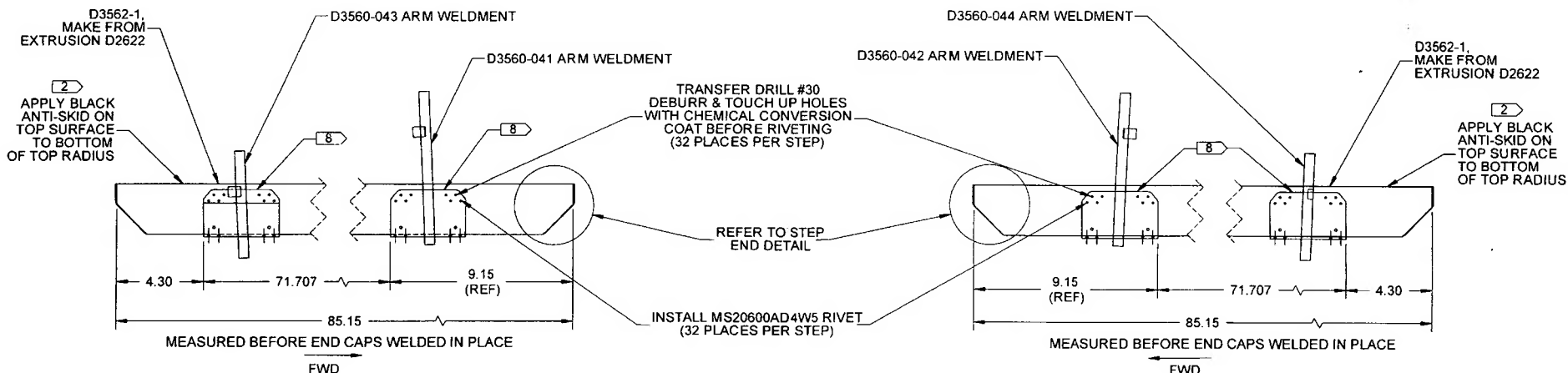
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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NOTE: Date & initial all entries



D3562-041 LH STEP ASSEMBLY

D3562-042 RH STEP ASSEMBLY

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH:
 - i) CHEMICAL CONVERSION COAT STEP EXTRUSION PER DART QSI 005 4.1 BEFORE ASSEMBLY
 - ii) POWDER COAT ASSEMBLY GLOSS WHITE (4.3.5.1) OR GREY SANDTEX (4.3.5.6) OR BLACK SANDTEX (4.3.5.7) OR GREEN SANDTEX (4.3.5.8) PER DART QSI 005 4.3
 - iii) BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 8.79 lbs
- 8) INSTALL ARM WELDMENTS WITH A LAYER OF MAGNOBOND 6398 BETWEEN THE ARM WELDMENT AND STEP EXTRUSION. FILL ANY TOOLING HOLES WITH MAGNOBOND 6398. CLEAN OFF EXCESS BEFORE POWDER COATING.
- 9) WELDING: PER DART QSI 004

QTY -041	QTY -042	P/N	DESCRIPTION
X		D3562-041	LH STEP ASSEMBLY
	X	D3562-042	RH STEP ASSEMBLY
1		D3560-041	ARM WELDMENT
1	1	D3560-042	ARM WELDMENT
1		D3560-043	ARM WELDMENT
1	1	D3560-044	ARM WELDMENT
32	32	MS20600AD4W5	RIVET
2	2	D2734	END PLATE

E	ADD QTY (2) TO D2734 END PLATE ON D3562-042	PH	08.01.11
D	REMOVE D2808 SPACER NOTE; REDRAWN IN SOLIDWORKS	DC	07.11.16
C	NOW MAGNOBOND, ADD D2808, REMOVE 4 RIVETS	CP	07.06.19
B	ARMS NOW RIVETED TO STEP	CP	07.01.15
A	NEW ISSUE	CP	06.09.26
REV.	DESCRIPTION	BY	DATE
DESIGN	gp	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	ef		
CHECKED	LE	DRAWING NO.	REV. E
MFG. APPR.		D3562	SHEET 1 OF 1
APPROVED		TITLE	SCALE
DE APPR.		STEP ASSEMBLY	1:5
DATE	08.01.11	COPYRIGHT © 2006 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	